

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-87 Date Opened: 18 May 2017 Title: Assembly

Aircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Bicycle Rack Product Model: LH Quantity: 1

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	KB
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	KB
Parts Distribution Sheet	KB
Sub Component Tags	N/A
Completed Certification	JC
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100210	0	Bike Rack Assembly	KB
100215	0	Bike Rack Base	KB

Traveller

	Initial or N/A
Assemble base	KB
Assemble aft frames	KB
Assemble forward frames	KB
Install placard	KB
Prepare cam straps	KB

Component Completion

	As Instructed
Quantity Complete on This Work Order	1
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	JC
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by:

Print: K. Bevans

Sign: Kelly Bevans

SCA: _____

Date: 27 May 17

ICC / Dual Inspection performed by:

Print: J. Clarke

Sign: _____

SCA: AD02

Date: 29-May-17

Work Order closed by:

Print: J. Clarke

Sign: _____

SCA: AD02

Date: 29-May-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

100227-01

Aircraft:

Airbus

Model:

AS350/355

Description:

Placard (Bike Rack, LH)

Supplier:

N/A

Color:

N/A

WO#:

2016-106

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bike Rack Base LH No. of pieces: 1

Manufacturer: Aero Design

Part No.: 100215-01-01 Serial/Batch No.: NSN

TTSN: NP TSO: N/A Rem.: N/A

Work Order No.: 2017-54

Remaining Tasks to be Performed: Assemble

Signature: [Signature] AD

Date: 11 Apr 17 Lic. No. / SCA 73-04

Serviceable



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bike Rack Standing Frame No. of pieces: 6

Manufacturer: Aero Design Ltd.

Part No.: 100220-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-56

Remaining Tasks to be Performed: Instal

Signature: [Signature]

Date: May 18/2017 Lic. No. / SCA AD-05

In Process



Aero Design Ltd.

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AMF 73-04

In Process

Remarks

18X POWDER COATED

15 SEPT 2016

AD 02



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: STRAP

No. of pieces: 42

Manufacturer: AERO DESIGN LTD.

Part No.: 100225-01

Serial/Batch No.: P0 16003 / 16058

TTSN: NA

TSO: NA

Rem.: NA

Work Order No.: 2016-118

Remaining Tasks to be Performed: POWDER COAT, INSPECT

Signature: [Signature]

Date: 14 SEPT 2016

Lic. No. / SCA AD02

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Drive Plate Assy. No. of pieces: 3

Manufacturer: Aero Design Ltd.

Part No.: 100222-11 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-12

Remaining Tasks to be Performed: Instal

Signature: David Murty

Date: May 24/2017 Lic. No. / SCA AD-05



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bike Rack Fixed Frame No. of pieces: 6

Manufacturer: Aero Design Ltd.

Part No.: 100221-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-56

Remaining Tasks to be Performed: Instal

Signature: David May

Date: May 18 / 2017 Lic. No. / SCA AD-05

In Process

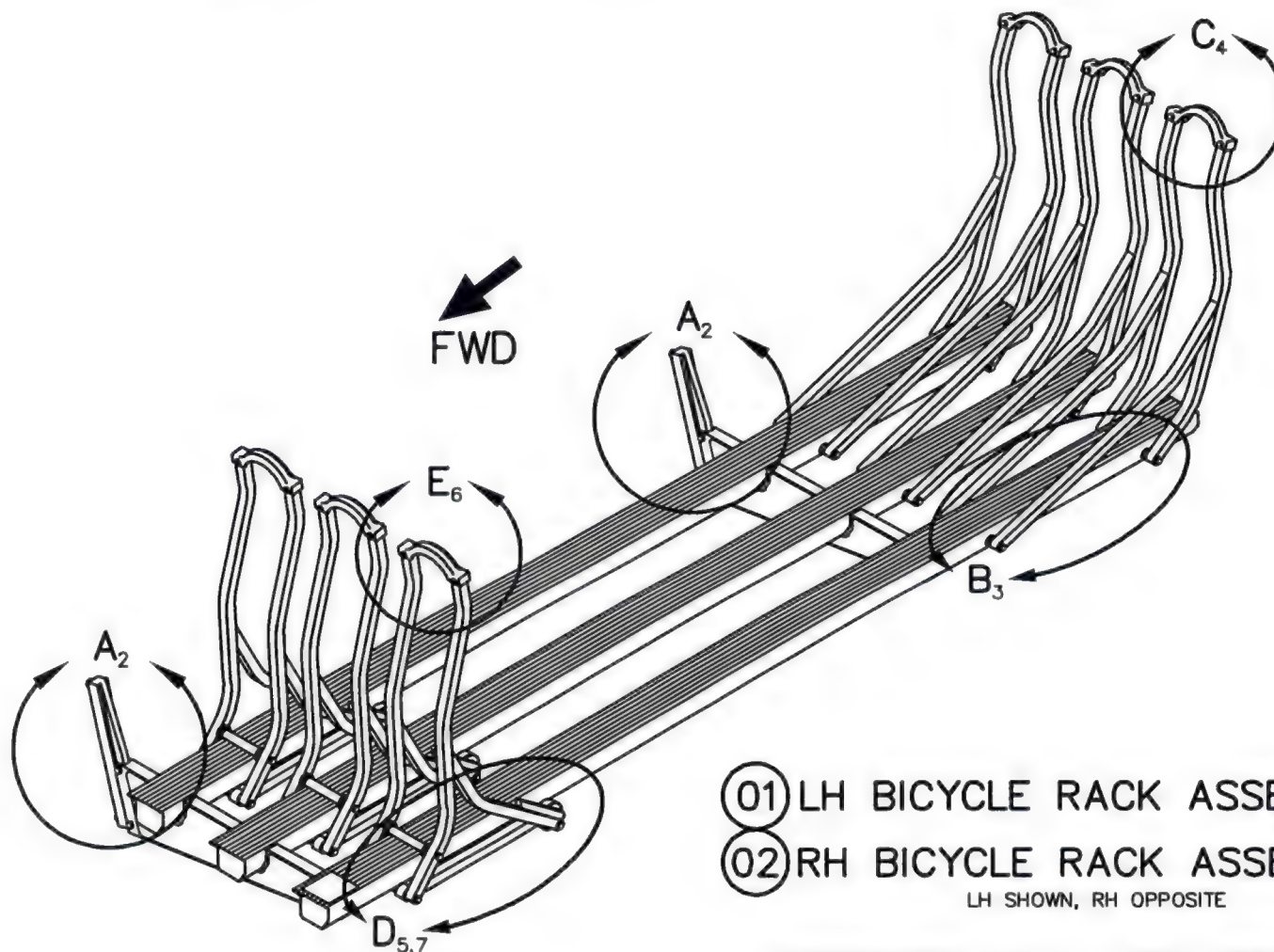


WO# 2017-87


Approved Manufacturing Facility 73-04

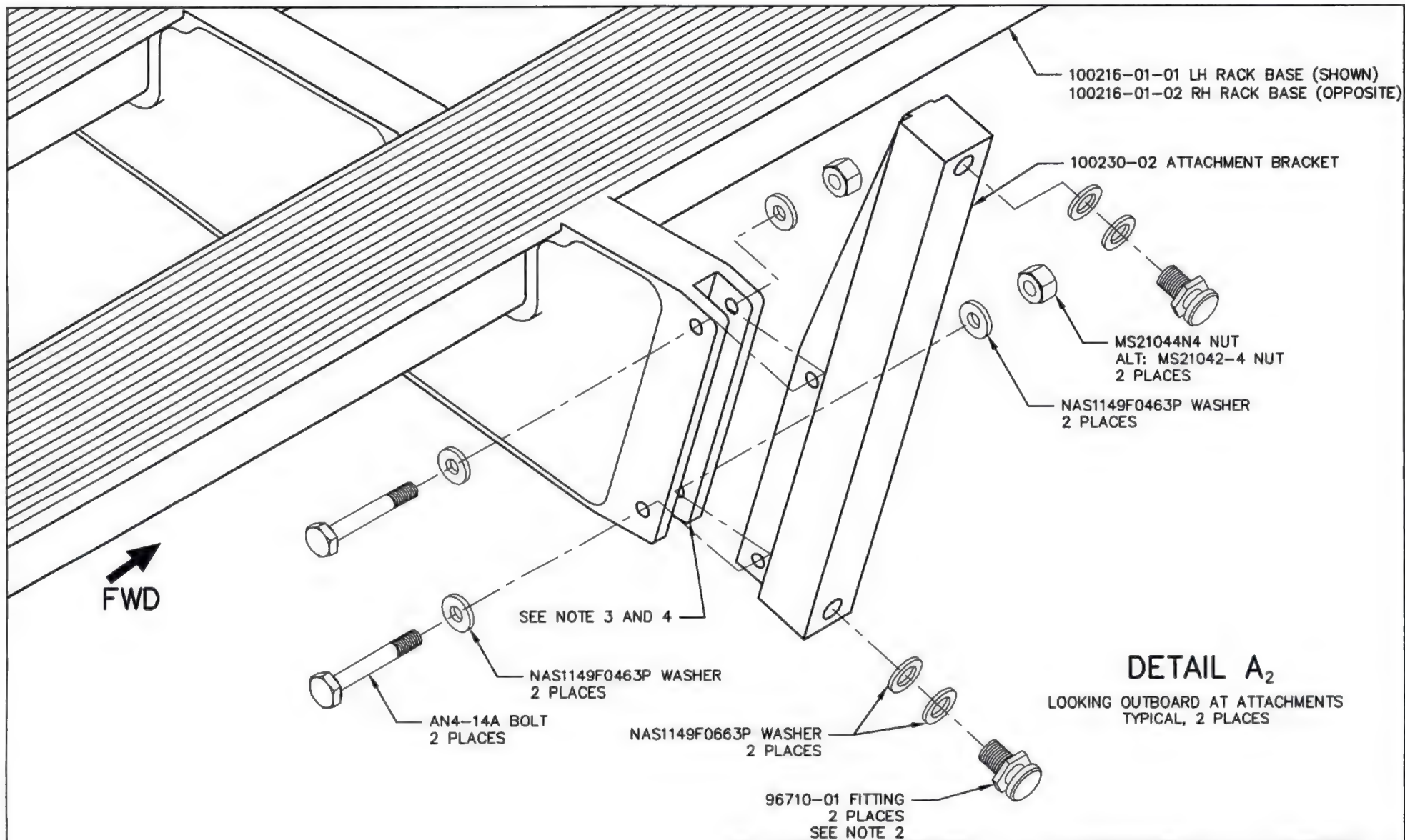
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

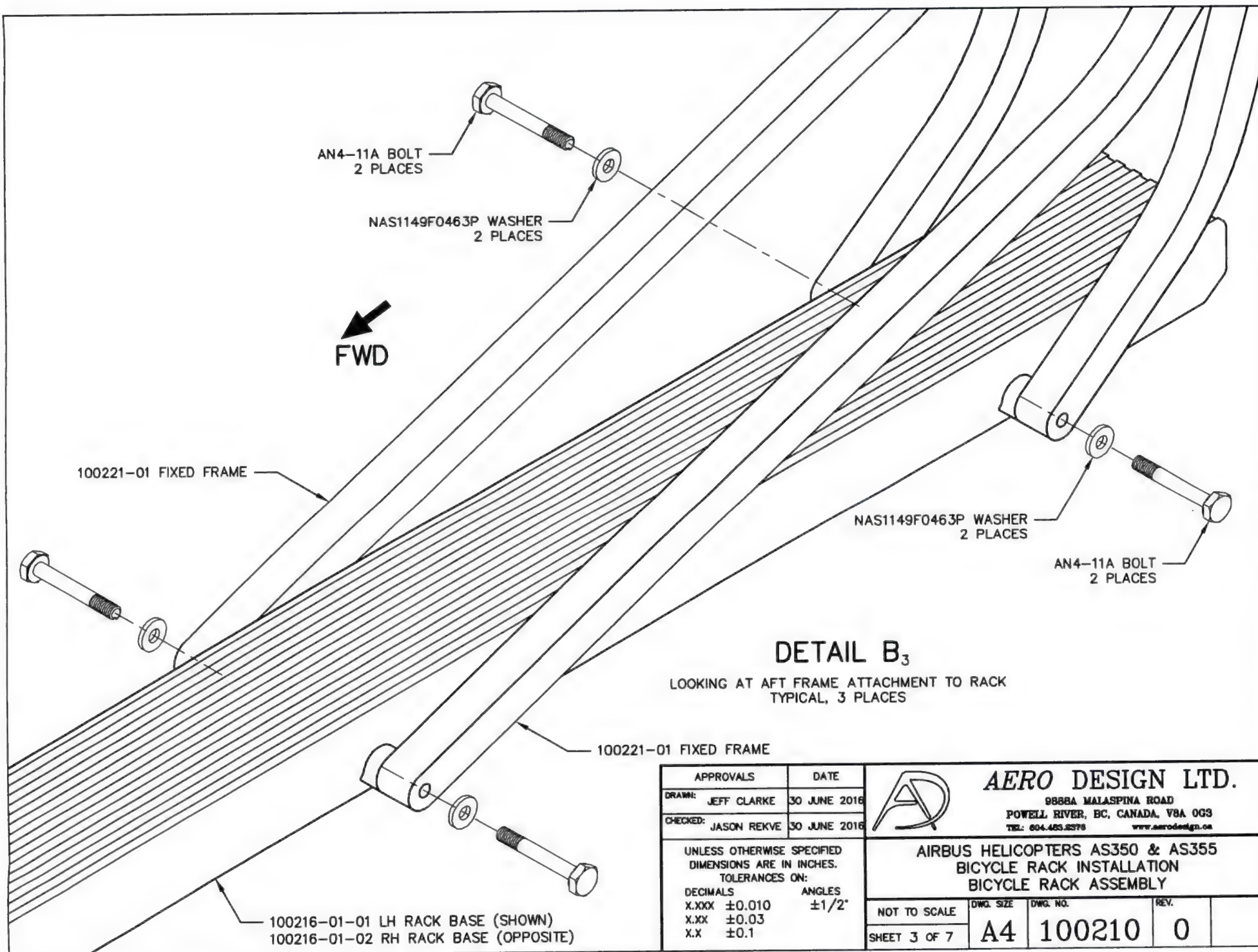



- ① LH BICYCLE RACK ASSEMBLY
 - ② RH BICYCLE RACK ASSEMBLY
- LH SHOWN, RH OPPOSITE

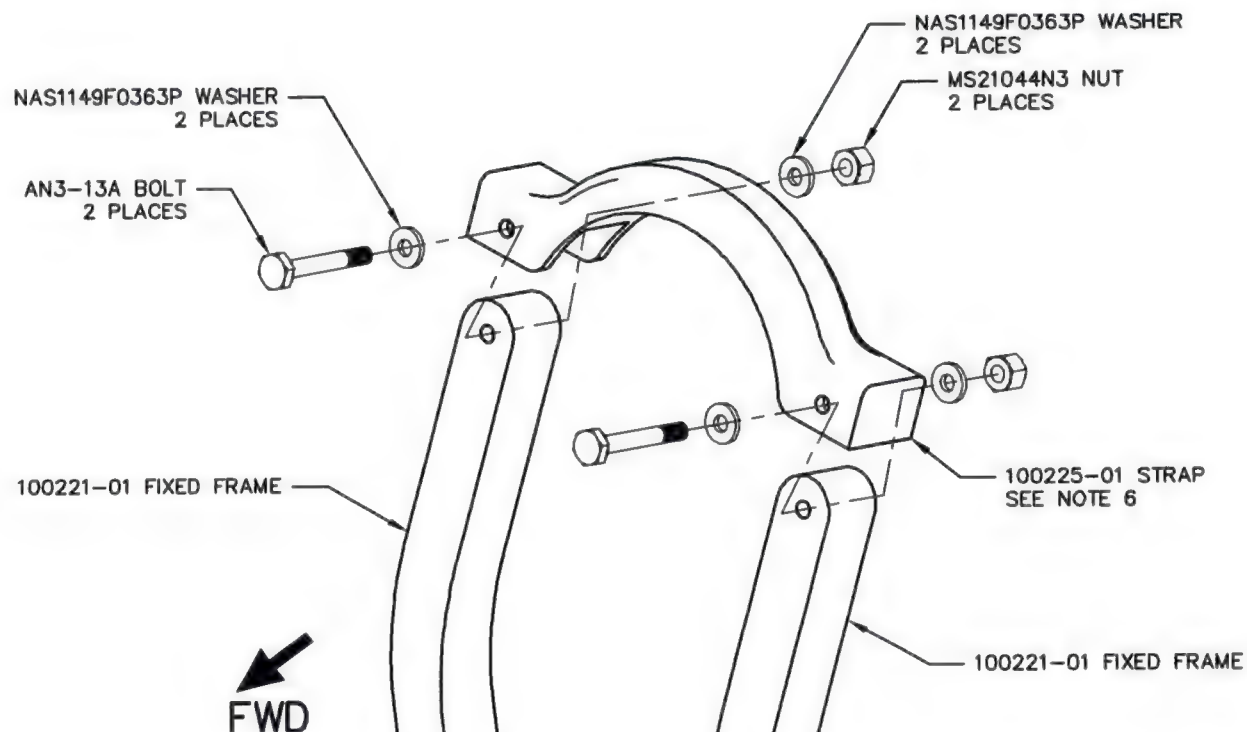
APPROVALS		DATE			AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.469.2376 www.aerodesign.ca		
DRAWN: JEFF CLARKE		30 JUNE 2016					
CHECKED: JASON REKVE		30 JUNE 2016					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				AIRBUS HELICOPTERS AS350 & AS355 BICYCLE RACK INSTALLATION BICYCLE RACK ASSEMBLY			
NOT TO SCALE				DWG. SIZE	DWG. NO.	REV.	
SHEET 1 OF 7				A4	100210	0	



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NOT TO SCALE		DWG. SIZE	DWG. NO.	REV.	
SHEET 2 OF 7		A4	100210	0	



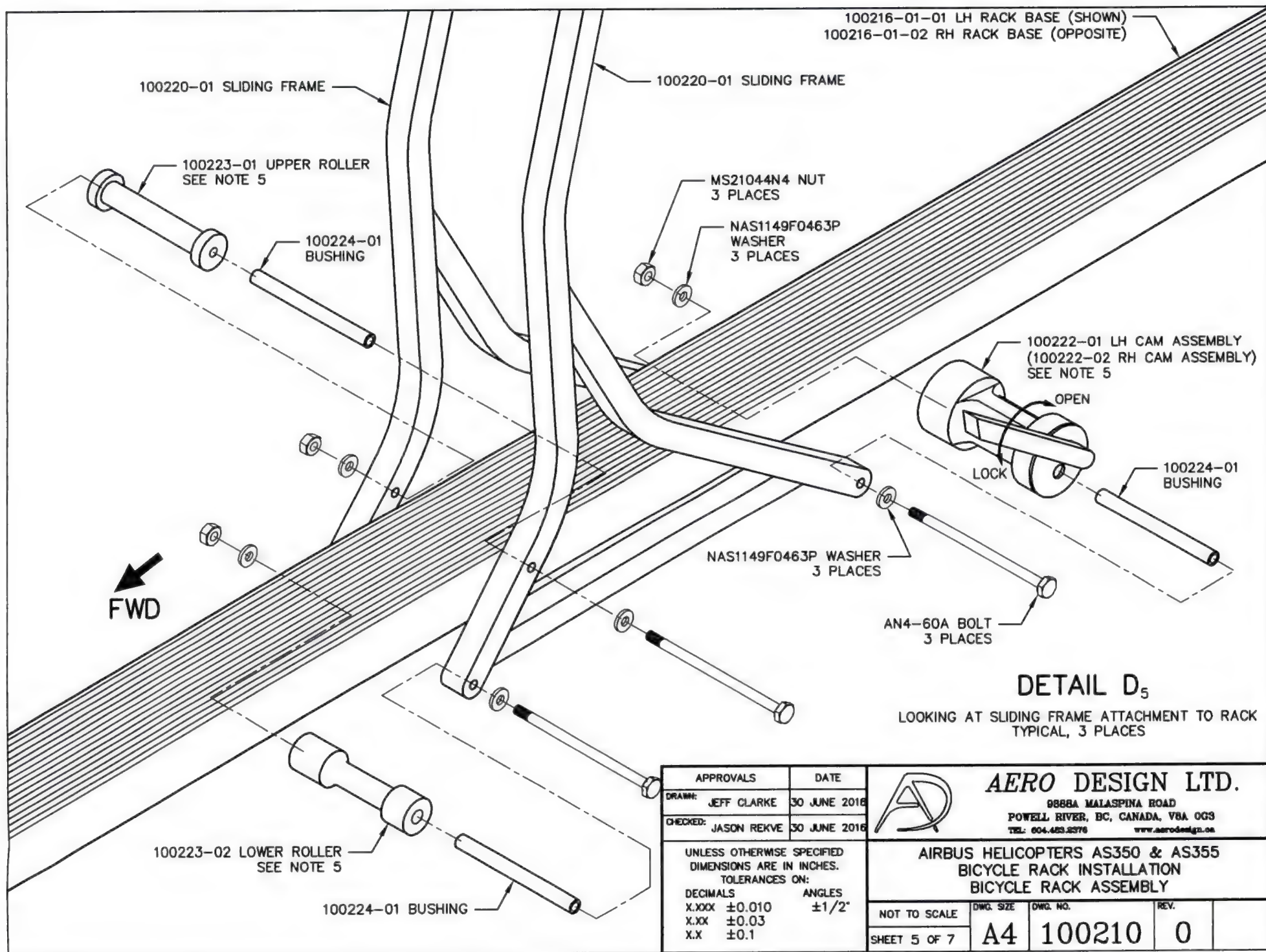
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NOT TO SCALE								
SHEET 3 OF 7				DWG. SIZE A4		DWG. NO. 100210		REV. 0

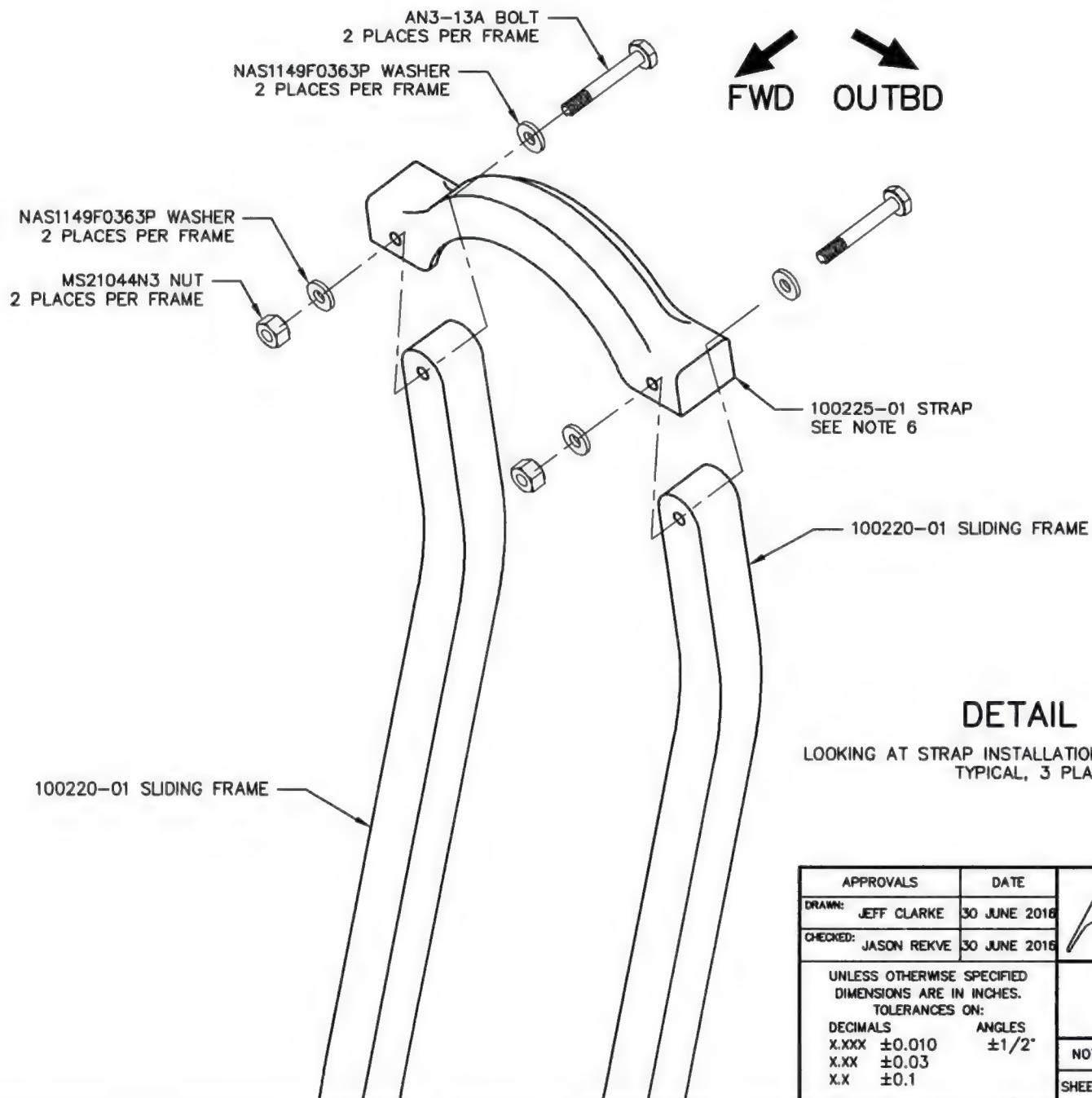



DETAIL C₄

LOOKING AT STRAP INSTALLATION ON AFT FRAME
TYPICAL, 3 PLACES

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NOT TO SCALE				DWG. SIZE	DWG. NO.	REV.
SHEET 4 OF 7				A4	100210	0





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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				AIRBUS HELICOPTERS AS350 & AS355 BICYCLE RACK INSTALLATION BICYCLE RACK ASSEMBLY			
NOT TO SCALE				DWG. SIZE	DWG. NO.	REV.	
SHEET 6 OF 7				A4	100210	0	

NOTES

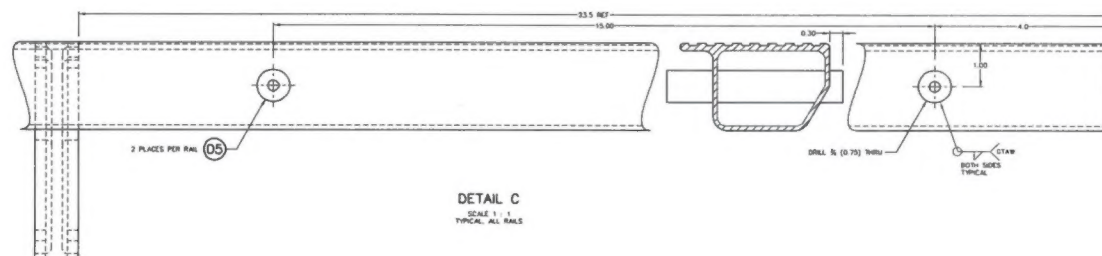
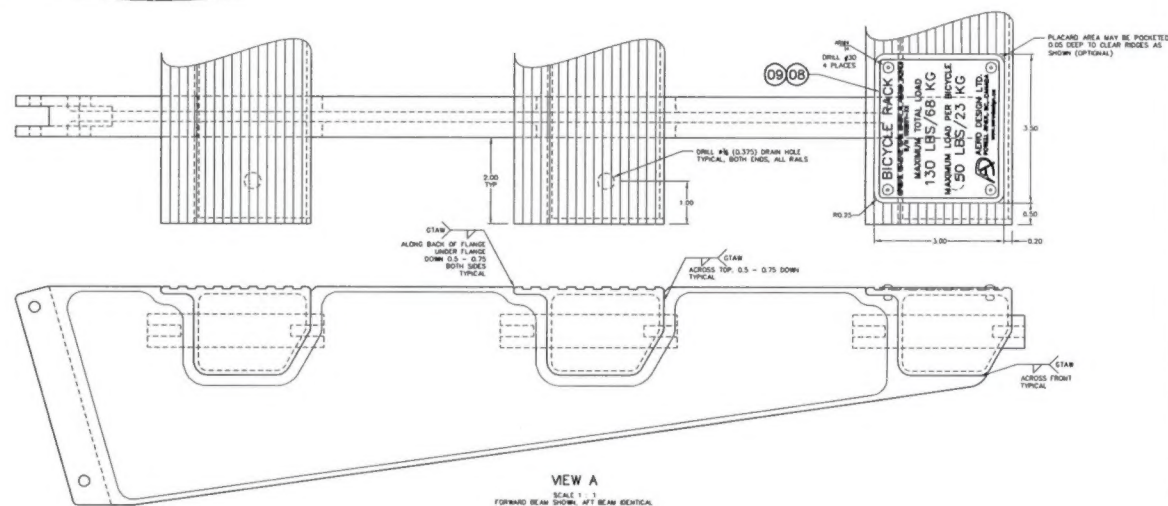
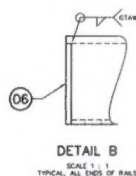
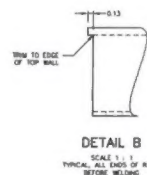
1. INSTALL ALL HARDWARE USING STANDARD SHOP PRACTICES AS OUTLINED IN AC43.13-1B, CHAPTER 7 "AIRCRAFT HARDWARE, CONTROL CABLES, AND TURNBUCKLES" OR STANDARD AIRCRAFT WORKERS MANUAL, SECTION 7 "SHOP PRACTICES". NAS1149F0432P WASHERS MAY BE SUBSTITUTED FOR NAS1149F0463P WASHERS TO MAINTAIN 2-4 THREADS BEYOND LOCKING AS REQUIRED ON ASSEMBLY.
2. APPLY NICKEL BASED ANTI-SEIZE COMPOUND TO THREADS OF FITTING ON INSTALLATION.
3. ANY PAINT OR POWDER COAT THAT PREVENTS INSTALLATION OF ATTACHMENT BRACKET MAY BE REMOVED WITH SCOTCH BRITE. APPLY ALODINE TO UN-COATED AREAS PRIOR TO ASSEMBLY IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS.
4. APPLY MASTINOX 6856K, TECTYL 894, OR EQUIVALENT CORROSION PREVENTATIVE COMPOUND TO FLANGE OF ATTACHMENT BRACKET AND BEAM SLOT PRIOR TO ASSEMBLY.
5. ENSURE ROLLERS ARE FREE TO ROTATE WITH CAM OPEN AND FRAME SLIDES ALONG RAIL. ENSURE CAM ROTATES TO LOCKED POSITION WITH LEVER PARALLEL TO FRAME. ENSURE FRAME CANNOT SLIDE ON RAIL WHEN CAM IS IN LOCKED POSITION.
6. ANY PAINT OR POWDER COAT THAT PREVENTS INSTALLATION OF STRAP MAY BE REMOVED WITH SCOTCH BRITE. APPLY ALODINE TO UN-COATED AREAS PRIOR TO ASSEMBLY IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS.
7. TORQUE AN3 BOLTS TO 12-15 IN-LBS (1.4-1.7 N-m).
TORQUE AN4 BOLTS TO 30-40 IN-LBS (3.4-4.5 N-m).
TORQUE 96710-01 FITTINGS TO 160-190 IN-LBS (18.1-21.5 N-m).

(12)	(12)	MS21042-3	NUT (ALTERNATE)
12	12	MS21044N3	NUT
24	24	NAS1149F0363P	WASHER
12	12	AN3-13A	BOLT
(13)	(13)	MS21042-4	NUT (ALTERNATE)
13	13	MS21044N4	NUT
A/R	A/R	NAS1149F0432P	WASHER
38	38	NAS1149F0463P	WASHER
9	9	AN4-60A	BOLT
4	4	AN4-14A	BOLT
12	12	AN4-11A	BOLT
8	8	NAS1149F0663P	WASHER
4	4	96710-01	FITTING (ALT: ANCRA 40088-14)
9	9	100224-01	BUSHING
3	3	100223-02	LOWER ROLLER
3	3	100223-01	UPPER ROLLER
3		100222-02	RH CAM ASSEMBLY
	3	100222-01	LH CAM ASSEMBLY
6	6	100220-01	SLIDING FRAME
6	6	100225-01	STRAP
6	6	100221-01	FIXED FRAME
2	2	100230-02	ATTACHMENT BRACKET
1		100215-01-02	RH RACK BASE
	1	100215-01-01	LH RACK BASE
		100210-01-02	02 RH BICYCLE RACK ASSEMBLY
		100210-01-01	01 LH BICYCLE RACK ASSEMBLY
02	01	PART NO.	ITEM DESCRIPTION
QTY	QTY	LIST OF MATERIALS	

APPROVALS		DATE			AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.8378 www.aerodesign.ca	
DRAWN: JEFF CLARKE		30 JUNE 2016				
CHECKED: JASON REKVE		30 JUNE 2016				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				AIRBUS HELICOPTERS AS350 & AS355 BICYCLE RACK INSTALLATION BICYCLE RACK ASSEMBLY		
NOT TO SCALE				DWG. SIZE	DWG. NO.	REV.
SHEET 7 OF 7				A4	100210	0

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF BOX ALUMINUM TO BE COMPLETED BY STAIN METHOD TO ANS268C.
WELDS SHOULD CONFORM TO AWS/AAS D19423.
3. FINISH ALUMINUM PARTS - AFTER WELDING:
 - THOROUGHLY DECREASE ALCODIC EPOXY PRIME AND POLYURETHANE PAINT.
 - ALTERNATE POWDER COATING
 - THOROUGHLY DECREASE USING TOP EXCEED POLYESTER TOP COAT BARR DEFENSE / 80% PHOSPHATE & 20% BY VOLUME.
 - COATING USING WATER BASED POLYESTER SUPER DUTY POWDER OR EQUIVALENT POWDER COAT MATERIAL.
 - AND PROCESS THAT DOES NOT EXCEED TEMPERATURE/TIME LIMITS ABOVE
 - CURE POWDER COATING AT 307T (107F) FOR 20 MINUTES (±3 MM).
4. INSTANT PLACED AFTER SURFACE FINISH IS DRY.

(02) RH RACK BASE
 (01) LH RACK BASE
 SCALE 1 : 4
 LH SHOWN, RH OPPOSITE



DETAIL C
SCALE 1 : 1
TYPICAL ALL RAILS

Q4	Q3	Q2	Q1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK	SIZE
1	2	3	4	09303-3-04	10	BLIND HOLE	AL, H93213-04			
1	2	3	4	100277-09	08	PLACARD				
1	2	3	4	100272-01	06	PLACARD				
1	2	3	4	100034-01	03	PLACARD				
1	2	3	4	85720-04	08	CAP				
1	2	3	4	100268-01	03	PLACARD				
1	2	3	4	100215-04	04	Box hole			78030	extrusion
1	2	3	4	100215-03	03	1/4" DIA.			78030	extrusion
1	2	3	4	100213-01-01	01	BRACK BASE				
1	2	3	4	100213-01-01	01	1/4" BRACK BASE				

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0193
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-87
6. Item 1.	7. Description Bicycle Rack Assembly (LH)	8. Part Number 100210-01-01	9. Qty. 1	10. Serial/Batch No. 100201-08	11. Status/Work New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations .		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 29 May 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

HELI TECNIA SPAIN

BICYCLE RACK ASSEMBLY – 100210

L/H

Work Order: 2017-87

Date Open: 25 May 2017

Complete
(initial or SCA #)

General

These instructions apply to assembly of AS350/AS355 bicycle racks. Refer to the following drawings, at the current revision, for dimensions and details:

100210, Revision 0 – Bicycle Rack Assembly

1. Assemble rack base:

KB

- a. Install 96710-01 Fitting with two NAS1149F0663P Washers on 100230-02 Attachment Bracket, 2 places per bracket. Apply nickel based anti-seize compound to threads.
- b. Torque Fittings to 160-190 in-lbs (18.1-21.5 N-m).
- c. Apply Mastinox 6856K, Tectyl 894, or equivalent corrosion preventative compound to flanges of attachment brackets and slots on inboard side of rack.
- d. Install 100230-02 attachment brackets on inboard side of rack base using AN4-14A Bolt, two NAS1149F0463P Washers, and MS21044N4 nut, two places per bracket, two brackets per rack base.
- e. Torque AN4 bolts to 30-40 in-lbs (3.4-4.5 N-m).

2. Assemble aft fixed frames, 3 places per rack:

KB

- a. Install two 100221-01 Fixed Frames using two AN4-11A Bolts and NAS1149F0463P Washers per frame.
- b. Install 100225-01 Strap across top of frames using two AN3-13A Bolts, NAS1149F0363P Washers (2 places) and MS21044N3 Nuts.
- c. Torque AN3 bolts to 12-15 in-lbs (1.4-1.7 N-m).
- d. Torque AN4 bolts to 30-40 in-lbs (3.4-4.5 N-m).

3. Assemble forward moveable frames, 3 places per rack:

KB

- a. Assemble 100223-01 Upper Roller, 100223-02 Lower Roller, and 100222-01 (LH) or 100222-02 (RH) Cam with 100224-01 Bushings.
- b. Locate two 100220-01 Moveable Frames on either side of rail. At the forward end (with two bushings), insert AN4-60A Bolt with NAS1149F0463P Washer through bottom bushing in frame, through Lower Roller assembled above, and through frame on opposite side. Install NAS1149F0463P Washer and MS21044N4 Nut on bolt.
- c. Raise assembly to rack. At forward end, insert AN4-60A Bolt with NAS1149F0463P Washer through upper bushing in frame, through Upper Roller assembled above, and through frame on opposite side. Install NAS1149F0463P Washer and MS21044N4 Nut on bolt.
- d. At aft end, insert AN4-60A Bolt with NAS1149F0463P Washer through aft bushing in frame, through Cam Assembly assembled above (lever down), and through frame on opposite side. Install NAS1149F0463P Washer and MS21044N4 Nut on bolt.
- e. Install 100225-01 Strap across top of frames using two AN3-13A Bolts, NAS1149F0363P Washers (2 places) and MS21044N3 Nuts.
- f. Torque AN3 bolts to 12-15 in-lbs (1.4-1.7 N-m).
- g. Torque AN4 bolts to 30-40 in-lbs (3.4-4.5 N-m).

BICYCLE RACK ASSEMBLY – 100210

Complete
(initial or SCA #)

4. Install placard:

- a. Install 100227-XX Placard using CR3213-4-04 CherryMax rivets, 4 places per placard. Locate placard as follows:
- Center placard in pocket at front end of outboard rail.
 - If pocket is not machined in rail, locate placard 5/8" from forward edge of outboard rail, with rivets centered on the high ridges.

KCB

5. Prepare cam straps, 3 per rack:

- Cut webbing of cam strap to 52" from end of buckle to end of strap. Cut at a 45° angle.
- Using a lighter, carefully melt the cut end.

KCB

6. Final Inspection:

- To be completed by a different person than the previous steps.
- Inspect bicycle rack 100210-01-XX for conformity to drawings.
 - Check bolts have been torqued.
 - Inspect cam straps.

AD
73-04
02